

Work Order ID 53130

October 23, 2009 8:03:08 AM



Page 1

Item ID: D3836-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 23/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

PD

Date: 09-10-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3836

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3836-2 and D3836-3 rib as per dwg D3836-2- remove identification markings 3- deburr

PD 09.10.23 (2)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

278 09/10/23

(042)
(72)

120

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- weld D3836-2 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836-1- weld D2327-3 spacer bushing as per dwg D3836-1 A/R ER316 S.S. Rod Batch: *M109213* 3- grind weld flush where indicated on dwg D

PD 09.10.24 (2)

Work Order ID 53130

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Page 2

Item ID: D3836-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 23/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Pl 09 10 27

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 808/27

2042



150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

24 09/10/27

2x

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Page 3

Item ID: D3836-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 23/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/18
MF 0910-27

Picklist Print

October 23, 2009 8:03:14 AM

Page 1

Work Order ID: 53130

Parent Item: D3836-042RevA

Parent Item Name: Rib Assembly (Basket Lid, RH)


Start Date: 23/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-3RevD		Manufactured	No			100	Each	46.0000	2.0000			
												

Spacer Bushing

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	46	
44274	27	
44365	9	
51126	10	

M304TS0.750W.065

Purchased

No

100

f

468.3119 3.7491



304 SQ Tube .75x.75x.065W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	468.3118947	
112398	468.311895	

② PD 09.10.24

PD 09.10.24

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

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09-10-23

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08/11/24 MB

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		

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HAWKESBURY, ONTARIO, CANADA

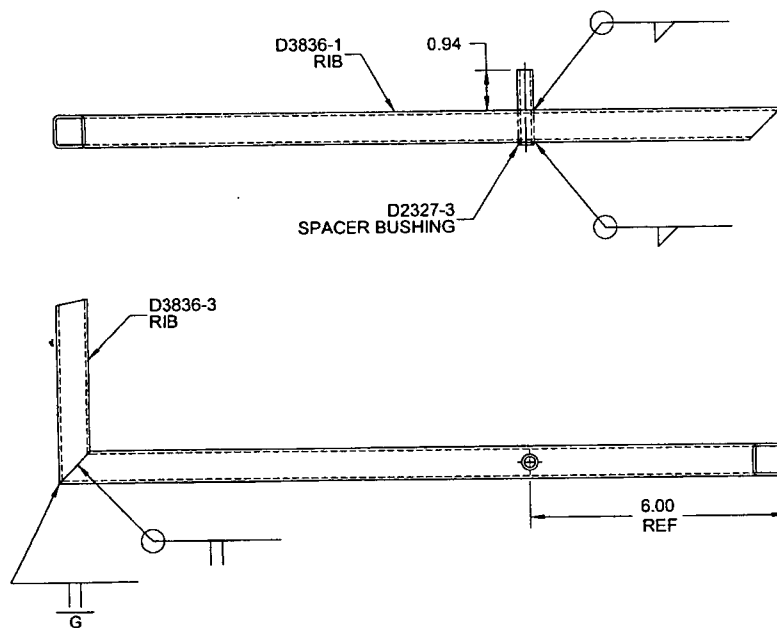
DRAWING NO. **D3836** REV. A
SHEET 1 OF 3
TITLE **RIB ASSY (BASKET LID)** SCALE NTS

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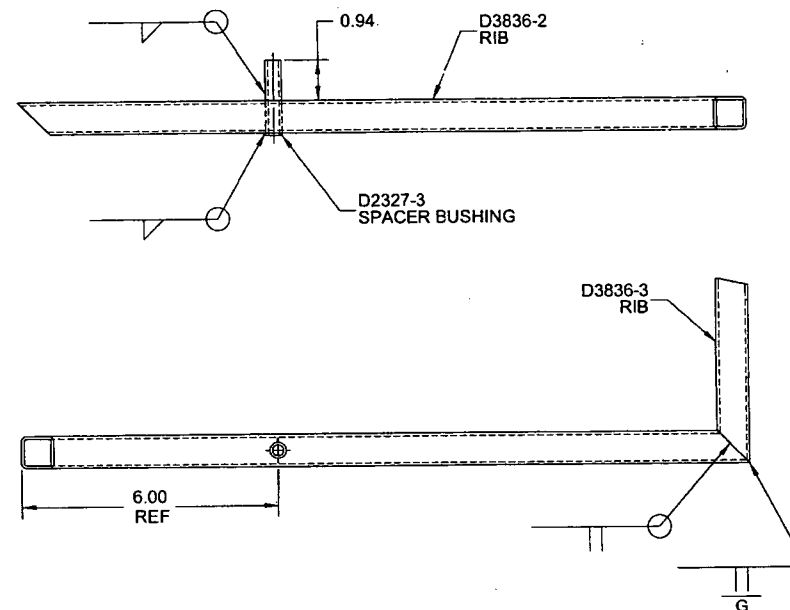
D3836-042 RIB ASSY (BASKET LID, RH)

D3836-041 RIB ASSY (BASKET LID, LH)

NOTES:
MATERIAL: N/A
FINISH: NONE
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: N/A
WEIGHT: 0.99 lbs EACH
WELD PER DART QSI 004







D3836-041 RIB ASSY (BASKET LID, LH)



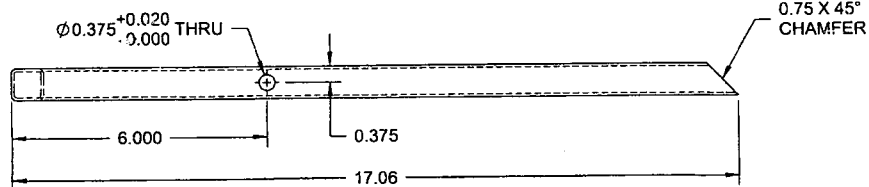
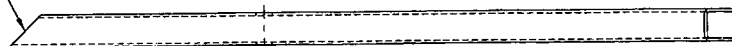
D3836-042 RIB ASSY (BASKET LID, RH)

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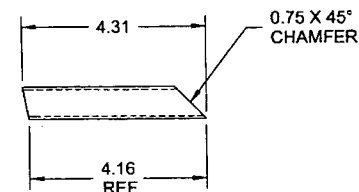
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MFG. APPR.		TITLE RIB ASSY (BASKET LID)	SHEET 2 OF 3
APPROVED			SCALE
DE APPR.			NTS
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0.75 X 45°
CHAMFER

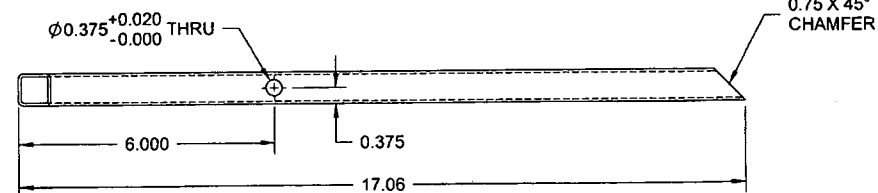
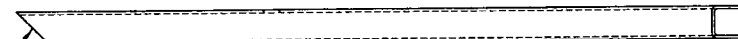


D3836-1 RIB

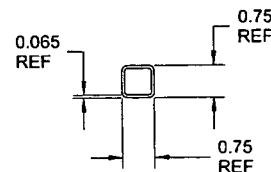


D3836-3 RIB

0.75 X 45°
CHAMFER



D3836-2 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/84

- NOTES:
- MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - FINISH: NONE
 - TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - UNITS: INCHES UNLESS OTHERWISE NOTED
 - BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - IDENTIFICATION: N/A
 - WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

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WORK ORDER
NO 53130

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MFG. APPR.	MP	D3836	SHEET 3 OF 3
APPROVED	MP	TITLE	SCALE
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